

Work Order ID 114802

March-13-14 9:53:11 AM

114802

Page 1

Item ID: D2803-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 3/13/14

Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/28/14

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2803

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per FILE D2803-1_blank

Dwg Rev: 3

Prog Rev: 3

2-Deburr if necessary

6061 .500x10"

6 0 Jm14-03-15

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA102

6 DAS 25 9-89 14-6-4

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

6 DAS 25 9-89 14-6-4

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Item ID: D2803-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 3/13/14 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/28/14 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
Hand Finish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
36
9-89

Picklist Print

March-13-14 9:53:10 AM

Page 1

Work Order ID: 114802

114802

Parent Item: D2803-1

D2803-1

Parent Item Name: Bracket

Start Date: 3/13/14

Required Date: 3/28/14

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A00.11.06New IssueEC

IPP Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM

IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased		No		100	f	55.0000	1.9167	13			

M6061T6B0 500X10 000

6061-T6 Bar .500 x 10.00

**

JM14-03-15

Location

Loc Qty

Loc Code

MAT005

55

M127015

12

M127180

24

M127464

19

127464.

DART AEROSPACE LTD		Work Order:	114802
Description: Bracket		Part Number:	D2803-1
Inspection Dwg: D2803 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.759	/		g-pin	
Ø0.191	+0.005/-0.000	.192	/			
Ø0.507	+0.000/-0.001	.506	/		-	
13.558	+/-0.010	13.558	/		HG	
Ø0.507	+0.000/-0.001	.507	/		-	
12.411	+/-0.010	12.411	/		HG	
2.654	+0.000/-0.001	2.6535	/			
0.437	+0.000/-0.001	.4365	/			
1.420	+/-0.001	1.420	/		Vern	SL-10
6.933	+/-0.010	6.933	/		~	CNC-02
0.250	+/-0.010	.247	/			
0.875	+0.000/-0.001	.8742	/		F-G+mic	SL-4
0.250	+0.000/-0.005	.247	/			
0.125	+/-0.010	.126	/		Vern	SL-10
0.125	+/-0.010	.128	/		-	
0.125	+/-0.010	.130	/		-	
0.125	+/-0.010	.125	/		-	
0.500	+/-0.010	.500	/		-	
0.562	+/-0.010	.560	/		-	
0.188	+/-0.010	.187	/		-	

Measured by:	SL	Audited by:	amf	Prototype Approval:	N/A
Date:	14-6-4	Date:	14/06/04	Date:	N/A

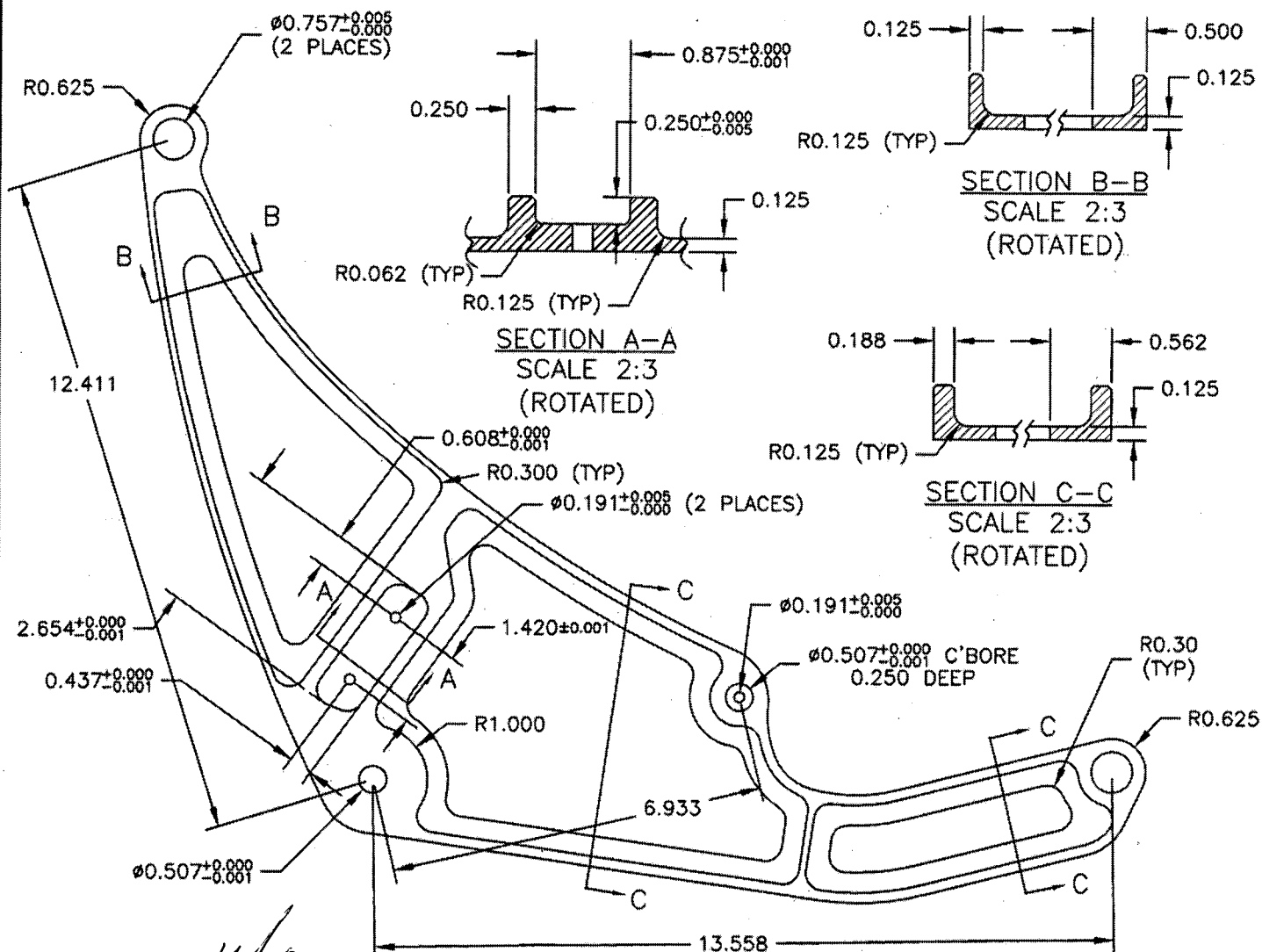
Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	07.07.18	12.625 dimension removed	KJ/JLM	AF



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803 REV. B SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		

RELEASED

05.03.11 *[Signature]*



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

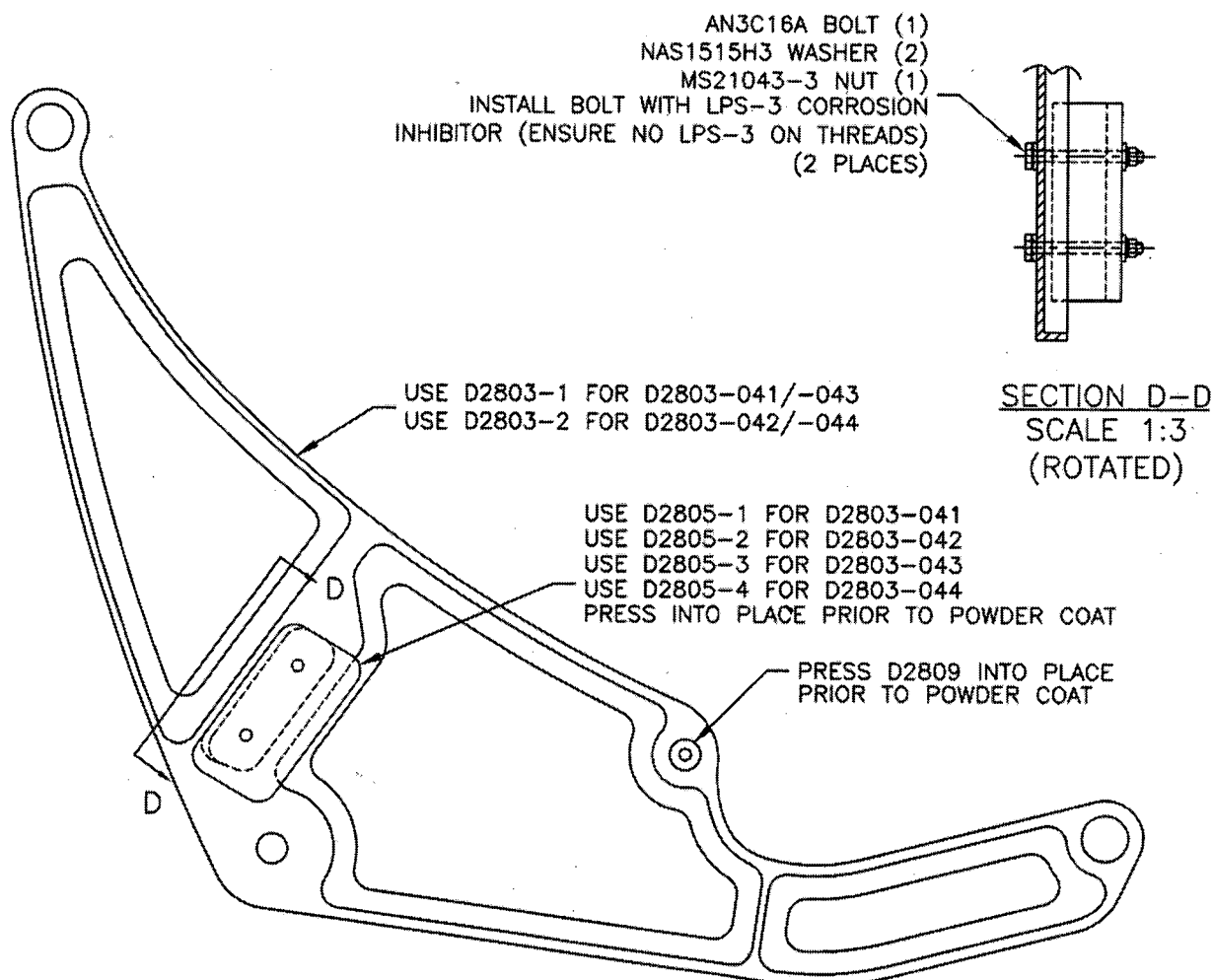
- 1) MACHINE PER DRAWING FILE "D2803.SLDPRJT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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